

Date: Thursday, 12/13/2007 11:23:51 AM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	: SADDLE KIT		
Job Number	36308			Part Number	: K10003		
Estimate Number	10532			Drawing Number	: IIN D205-634 REV D		
P.O. Number	:			Project Number	: N/A		
This Issue	12/13/2007	S.O. No.	:	Drawing Revision	: D		
Prsht Rev.	: NC			Material	:		
First Issue	/: /	Type	: SMALL /MED FAB	Due Date	: 1/12/2008		
Previous Run	36307			Qty:	8	Um:	Each
Written By	<i>JH</i>			<i>JH</i>			
Checked & Approved By	<i>JH</i>						
Comment	Est : 03.01.16 Reformat: Incorporated D205-641-011			KJ/RF			
	Est : J 06-07-25 As per DSI 9344			JLM			
	Est : K 06.11.17 Per K10003 Rev C			KJ			
	Est Rev: L 07.01.12 Document Record for copying bluefile rmv			KJ			

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	DC	DOCUMENT CONTROL	
 			
Comment: DOCUMENT CONTROL Create White labels only per PPP K10003 CHG 005			
2.0	PACKAGING 1	PACKAGING RESOURCE #1	
 			
Comment: PACKAGING RESOURCE #1 Pick Packing Kit			
3.0	D2570	Bushing	
 			
Comment: Qty.: 24.0000 Each(s)/Unit Total : 192.0000 Each(s) Bushing Pick: Qty Part Number Description Batch 24 D2570 Bushing <i>36480</i> <span style="float: right;"><i>AS 08/02/08</i> <i>(X)</i></span>			
4.0	D2571	Saddle, Fwd, Out	
 			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) Saddle, Fwd, Out Pick: Qty Part Number Description Batch 1 D2571 Saddle <i>3593147 36302x1</i> <i>AS 08/02/08</i> <i>(X)</i>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 12/13/2007 11:23:51 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT

Job Number: 36308

Part Number: K10003

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0 D2572

Saddle, Fwd, In



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Saddle, Fwd, In

Pick:

Qty Part Number  
1 D2572

Description  
Saddle

Batch

36323

AS 08/02/08

6.0 D2573

Saddle, Aft, Out



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Saddle, Aft, Out

Pick:

Qty Part Number  
1 D2573

Description  
Saddle

Batch

B 36324 x7 35933x1 AS 08/02/08

7.0 D2574

Saddle, Aft, In



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Saddle, Aft, In

Pick:

Qty Part Number  
1 D2574

Description  
Saddle

Batch

36325

AS 08/02/08

8.0 D27361

Lug Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Lug Assembly

Pick:

Qty Part Number  
1 D2736-1

Description  
Bracket

Batch

36330

AS 08/02/08

9.0 D27363

Lug Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Lug Assembly

Pick:

Qty Part Number  
1 D2736-3

Description  
Bracket

Batch

35064

AS 08/02/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 12/13/2007 11:23:51 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services			Drawing Name: SADDLE KIT
Job Number: 36308			Part Number: K10003
Job Number:			
Seq. #:	Machine Or Operation:		Description :
10.0	D2747	Sel Screw	
X			
Comment: Qty.: 4.0000 Each(s)/Unit Total : 32.0000 Each(s)	Set Screw		
Pick:			
Qty	Part Number	Description	Batch
4	D2747	Socket Head Set Screw	35758x15 X all same batch
11.0	D2876	Saddle Spacer	
X			
Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)	Saddle Spacer		
Pick:			
Qty	Part Number	Description	Batch
2	D2876	Spacer	33543 AS 08/02/08 X
12.0	D2877	Saddle Spacer	
X			
Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)	Saddle Spacer		
Pick:			
Qty	Part Number	Description	Batch
2	D2877	Spacer	36276 AS 08/02/08 X
13.0	D2968041	Tow Ring	
X			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)	Tow Ring		
Pick:			
Qty	Part Number	Description	Batch
1	D2968-041	Tow Ring	31957 AS 08/02/08 X
14.0	D35331	Set Screw	
X			
Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)	Set Screw		
Batch:	28093 AS 08/02/08 X		
15.0	AN46A	Bolt	
X			
Comment: Qty.: 16.0000 Each(s)/Unit Total : 128.0000 Each(s)	Bolt		
Pick:			
	M105810 AS 08/02/08 X		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 12/13/2007 11:23:51 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT

Job Number: 36308

Part Number: K10003

Job Number:



Seq. #:

Machine Or Operation:

Description :

Qty	Part Number	Description	Batch
16	AN4-6A	Bolt	

16.0 AN446A Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 32.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
4	AN4-46A	Bolt	M106277

17.0 AN451A Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 64.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
8	AN4-51A	Bolt	M105810 X10

AS 08/02/08 X8

All Same Batch##

18.0 AN612A Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 64.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
8	AN6-12A	Bolt	M105558 X31

M106513 X33  
M105558 X31

AS 08/02/08 X8

19.0 AN960JD416 Washer



Comment: Qty.: 32.0000 Each(s)/Unit Total : 256.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
32	AN960JD416	Washer	M106780

AS 08/02/07 X8

20.0 AN960JD616 Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 64.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
8	AN960JD616	Washer	M105906 X13

105906

\* old batch not in computer

AS 08/02/07 X8

M106883 X51

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 20/02/12  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 12/13/2007 11:23:51 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT

Job Number: 36308

Part Number: K10003

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

AN9704

Washer

~~HTT~~



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

Pick:

Qty 1

Part Number AN970-4

Description Washer

Batch

105442

AS 08/02/07 (x8)

22.0

MS21042L4

Nut

~~HTT~~



Comment: Qty.: 29.0000 Each(s)/Unit Total : 232.0000 Each(s)

Nut

Pick:

Qty 29

Part Number MS21042L4

Description Nut (or MS21042-4)

Batch

M10593e

AS 08/02/07 (x8)

23.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT KITS 100% FOR COMPLETENESS

AS 08/02/07 (x8)

24.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Per HT

AS 08/02/08 (x8)

25.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

AS 08/02/10

Job Completion



min 2008 2/11

(8)

W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN <i>A</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>TT</i>	DRAWING NO. K10003	REV. C SHEET 1 OF 1
DATE 06.11.07		TITLE SADDLE KIT	SCALE NTS
A	00.06.01	NEW ISSUE	
B	00.11.22	ADD D2707-041 OPTION	
C	06.11.07	ADD D3533-1	

**RELEASED**06.11.13 *#*

THIS KIT CONTAINS PARTS AND PAPERWORK APPLICABLE TO THE FOLLOWING SKIDTUBE AND SADDLE INSTALLATIONS:

AIRCRAFT	INSTALLATION
BELL 205/210/212/412	D205-634-011 D205-634-015
BELL 204	D204-635-011

THE FOLLOWING PARTS SHOULD BE USED PER THE RELEVANT DRAWINGS AND THE FOLLOWING TABLE (REF):

PART NUMBER	K10003	D205-634-011 D205-634-015	D204-635-011
D205-641-011	1	1	1
D2570	16	16	16
D2571	1	1	1
D2572	1	1	1
D2573	1	1	1
D2574	1	1	1
D2747	4	4	4
D2876	2	2	2
D2877	2	2	2
D2707-041 (or D2968-041)	1	1	1
D3533-1	2	2	2
AN4-51A	8	8	8
AN4-6A	16	16	16
AN6-12A	8	8	8
AN960JD416	32	32	32
AN960JD616	8	8	8
*AN960JD1016	1	1	1
AN970-4	1	1	1
MS21042-4 (OR L4)	25	25	25

\* REQUIRED WITH D2707-041 ONLY

NO. *36308*

Copyright © 2000 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.